

Date:
User:Friday, 23/01/2009 8:46:10 AM
Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LONG PIN BRACKET
Job Number :	45176		
Estimate Number :	11204		
P.O. Number :		Part Number :	D333011
This Issue :	23/01/2009	Drawing Number :	D3330 REV D
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	D
Previous Run :	44203	Material :	
Written By :		Due Date :	05/02/2009
Checked & Approved By :	JUD 09.01.23	Qty:	12 Um: Each
Comment :	Est. A05.01.13 New issue KJ/JLM est b 07.05.14 rev c dwg ec est C 07.12.12 rev D dwg EC verified by:DD		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M1010B2500X01000

1010-1025 Steel Bar 2.50 x 1.00



Comment: Qty.: ~~0.2134~~ f(s)/Unit Total: 3.2810 f(s)

1010-1025 Steel Bar

Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel(

M1010-B2.500x01.000)

Identify for D3330-11

Batch: M107220

mk 09/01/27

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks: 2.500" x 1.000" x 5.00" long (+/-0.030)

mk 09/01/27

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA479 and Dwg D3330

Identify as D3330-11

Deburr

mk 09/01/31

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE




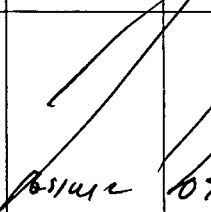
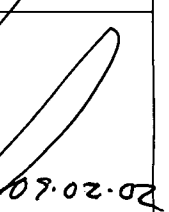
Comment: INSPECT PARTS AS THEY COME OFF MACHINE

A

mk 09/01/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3330-11 PAR #: N/A Fault Category: Prod / Mechanical Part NCR: (Yes) No DQA: 10 Date: 09/02/03
D3330-041 D712-707-041
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 12 Date: 09/02/03

NCR: <u>45176</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/01/31	3.0	blank install emitting way for operation 2, piece is scrap RL operator error LACK of attention machined into the hole.		Scrap & destroy. No replace.	mwr 09/01/31	Inf 09/02/02		

NOTE: Date & initial all entries

Date: Friday, 23/01/2009 8:46:10 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG PIN BRACKET

Job Number: 45176

Part Number: D333011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

9th 09/02/02

(8)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Carl*

9/2/02

20

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/03

Job Completion



U 09.02.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 45176
Description: Long Pin Bracket		Part Number: D3330-11
Inspection Dwg: D3330	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.00	+/-0.030	5.01	✓			
4.625	+/-0.010	4.630	✓			
0.260	+/-0.010	.258	✓			
Ø0.594	+0.005/-0.000	Ø.595	✓			
0.875	+/-0.010	.875	✓			
0.838	+/-0.010	.837	✓			
0.700	+/-0.010	.700	✓			
0.500	+/-0.010	.509	✓			
2.25	+/-0.030	2.25	✓			
0.950	+/-0.010	.948	✓			
Ø0.531	+0.005/-0.000	Ø.532	✓			
Ø0.348	+0.005/-0.000	Ø.348	✓			
Ø0.516	+0.005/-0.000	Ø.517	✓			
0.467	+/-0.010	.465	✓			
1.250	+/-0.010	1.250	✓			
1.00	+/-0.030	.99	✓			
0.10 x 45°	+/-0.5°	Ø8 x 45°	✓			

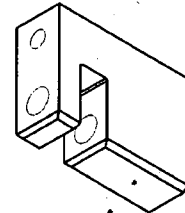
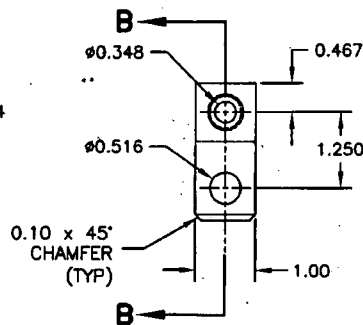
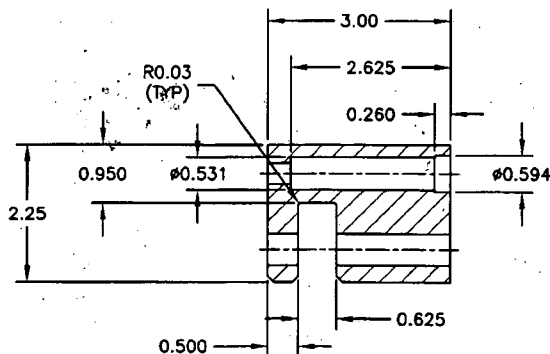
Measured by: mms	Audited by: mms	Prototype Approval:	N/A
Date: 09/01/31	Date: 09/02/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.05.10	New Issue	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	07.05.16	Dwg Rev updated	KJ/EC	
D	07.11.23	0.838 was 0.837	KJ/EC/DD	



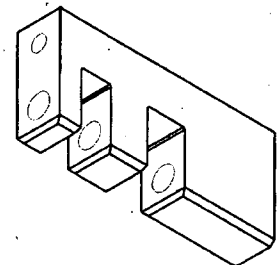
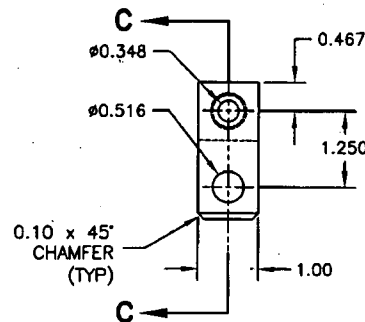
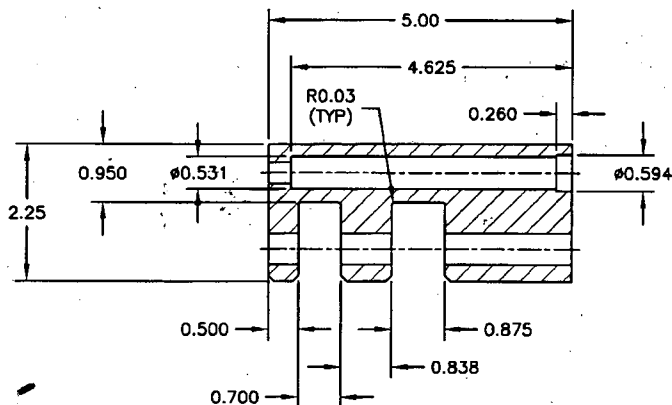
DESIGN <i>[Signature]</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3330	REV. D SHEET 9 OF 9
DATE 07.12.06	TITLE FRAME WELDMENT		SCALE 1:3

RELEASED
07.12.07



SECTION B-B

D3330-13 SHORT PIN BRACKET



SECTION C-C

D3330-11 LONG PIN BRACKET

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45176

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